

Work Order ID 152770

Monday, November 07, 2016 3:09:28 PM

647.3801
B 152770
REV N/C***152770***

Page 1

Item ID: 647.3801

Revision ID:

Item Name: 412 Upper Cutter Assy

Start Date: 11/15/2016 Start Qty: 3.00

3

Required Date: 11/18/2016 Req'd Qty: 3.00

3***N900040100***Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: NOV 10 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

647.3800

n/c

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

3X 16/11/22

DAS
36
9-89

120

120

Small Fab

Memo

0.00

0.07

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 135479
exp. date: 04/18

3X 16/11/23

DAS
36
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.01

Quality Control

3 NOV 24 2016

DAS
38
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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Work Order ID 152770

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Page 2

Item ID: 647.3801 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 412 Upper Cutter Assy
Start Date: 11/15/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 11/18/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CCF028</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.05							
Quality Control									

DAS
6
9-89

NOV 25 2016

DAS
21
9-89

NOV 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 152770

152770

Parent Item: 647.3801

647 3801

Parent Item Name: 412 Upper Cutter Assy

Start Date: 11/15/2016

Required Date: 11/18/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701		Manufactured	No			110	Each	0.0000	1	3			
646 9701						<i>B 149606</i>			**	DAS		NOV 22 2016	
Cutter Sub Assembly										30			
NAS1149FN832P		Purchased	No			110	Each	1,519.000	6	18			
NAS1149FN832P									**			<i>16/11/22</i>	DAS
Washer													36
													9-89

Location

Loc Qty

Loc Code

GA
M133769
M135058
ST263
M135603

1389
89
1300
130
130

MS21042L08 Purchased No

110 Each 1,070.000 3 9

MS21042L 08

Nut

Location

Loc Qty

Loc Code

GA
m135274
ST303
m135672
m135766
m135948
m135978

50
50
1020
20
200
300
500

7

16/11/22 **DAS**
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
08 08 08							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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Picklist Print

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Page 2

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Parent Item: 647.3801

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Parent Item Name: 412 Upper Cutter Assy

Start Date: 11/15/2016

Required Date: 11/18/2016

Start Qty: 3.00

Required Qty: 3.00

MS27039-08-19

Purchased

No

110

Each

315.0000

3

9

MS27039-08-19

Screw

16/11/22

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

182

m135948

182

ST277

133

m135865

33

m136042

100

647.3910

Manufactured

No

110

Each

13.0000

1

3

647.3910

412 Upper Deflector

DAS
30
9-89

NOV 22 2016

Location

Loc Qty

Loc Code

cck082

13

124426

1

144768

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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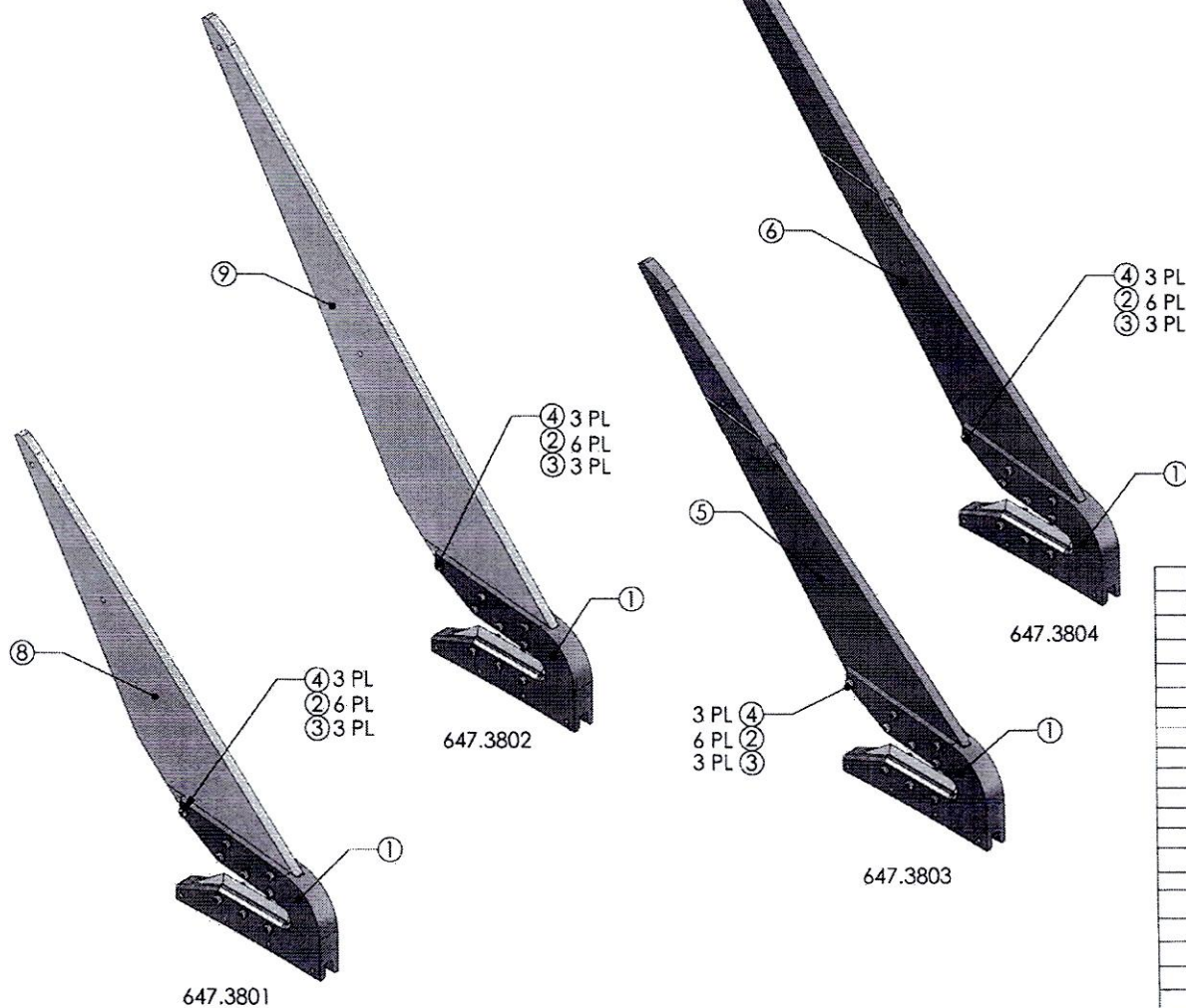
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NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 5, 6, 7, & 8 UPON ASSEMBLY

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: PP1		N/C
1	FINAL RELEASE	06/08/99	P. BPAVO

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NO. 152770 MJS
16-11-10



QTY	1	9	647.3911	212 UPPER DEFLECTOR		
		1	8	647.3910	412 UPPER DEFLECTOR	
A/R	A/R	A/R	A/R	7	601.2045	RTV. LOCTITE 598
1				6	647.3902	LOWER DEFLECTOR ASSY
	1			5	647.3901	LOWER DEFLECTOR ASSY
3	3	3	3	4	601.2765	SCREW
3	3	3	3	3	601.1541	LOCKNUT
6	6	6	6	2	601.2764	WASHER
1	1	1	1	1	646.9701	CUTTER SUB ASSY
					647.3804	LOWER CUTTER ASSY HIGH
					647.3803	LOWER CUTTER ASSY LOW
					647.3802	212 UPPER CUTTER ASSY
					647.3801	412 UPPER CUTTER ASSY
.3804	.3803	.3802	.3801	FIND #	PART #	DESCRIPTION
						MATL
						SPEC.
NEXT ASSY (\$)				PARTS LIST		
647.3700				APICAL INDUSTRIES		
				2608 TEMPLE HEIGHTS DR.		
				OCEANSIDE, CA. 92056-3512 (760)724-5300		
				CUTTER ASSY		
				647.3800		
				SCALE NONE		
				SHEET 1 OF 1		